

Date: Thursday, 3/2/2006 3:07:33 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RAPPEL ANCHOR
Job Number	: 26029	Part Number	: D2224
Estimate Number	: 11069	Drawing Number	: D2224 REV E
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 3/2/2006 S.O. No. : N/A	Drawing Revision	: E
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 3/26/2006
Previous Run	: N/A	Qty:	6 Um: Each
Written By	: <u>See comment below</u>		
Checked & Approved By	: <u>JA 06.03.02</u>		
Comment	: Est Rev:D 02.04.23 Add note for grain direction & inspect 8, 21 N G		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M7075T73B2500X0325	7075-T73 Bar 2.5 x 3.25"
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Comment: Qty.: 0.2321 f(s)/Unit Total : 1.3923 f(s)
 7075-T73 Bar 2.5 x 3.25"
 (M7075T7B0325X0320)
 Batch: M17646

ml 06/03/19 6

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.660" +.030" / -.010"
 *****Note grain direction *****

ml 06/03/19 6

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio D2224 & Dwg D2224

2-Deburr & Tumble

ml 06/03/20 6

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/03/20 6

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 06/03/20 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *PS* Date: 06/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:07:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RAPPEL ANCHOR

Job Number: 26029

Part Number: D2224

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 0000842

Red Anodize as per Dwg D2224 MIL-A-8625

AP 06/04/11

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

AP 06/04/11

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ANODIZE

06/04/11 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5130

AP 06/04/11 (6)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/11 (6)

Job Completion



u 06/04/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

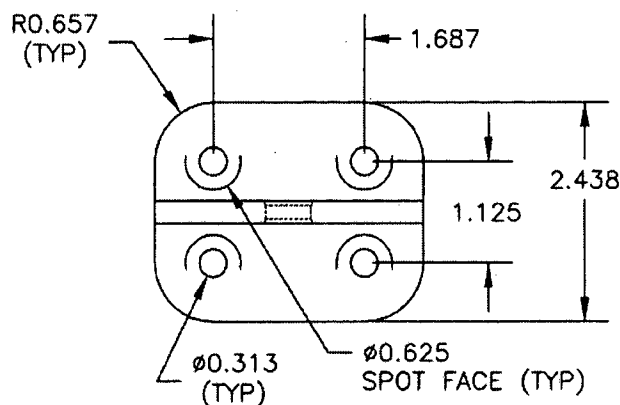
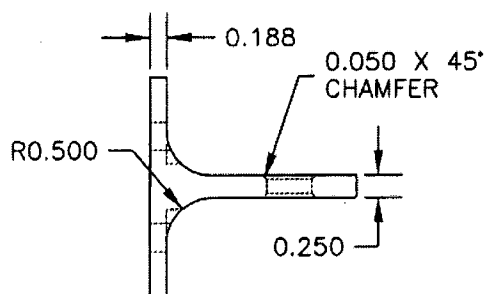
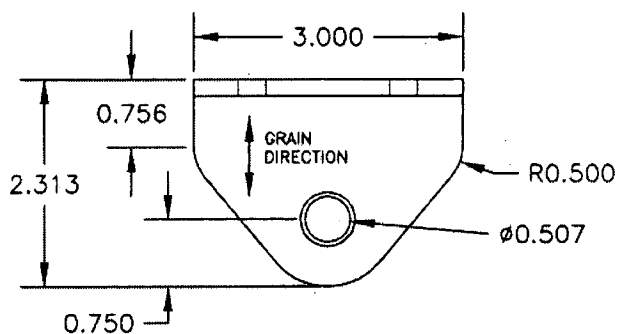
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



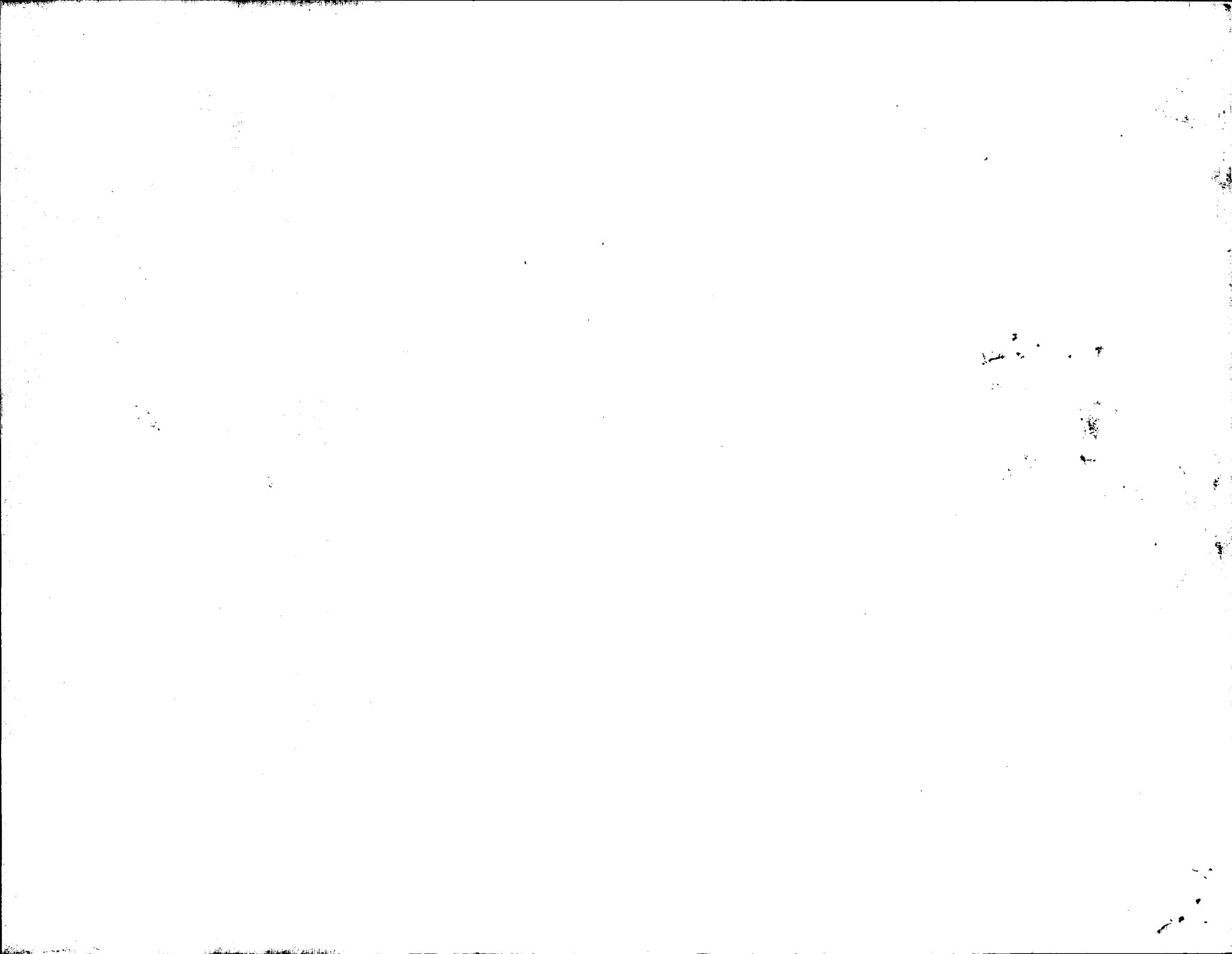
DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	

RELEASED
99.09.11 KE



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
FINISH : ANODIZE RED PER MIL-A-8625
BREAK ALL UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26029



DART AEROSPACE LTD		Work Order:	26029
Description: RAPPEL ANCHOR		Part Number:	D2224
Inspection Dwg:	Rev:	Page 1 of 1	

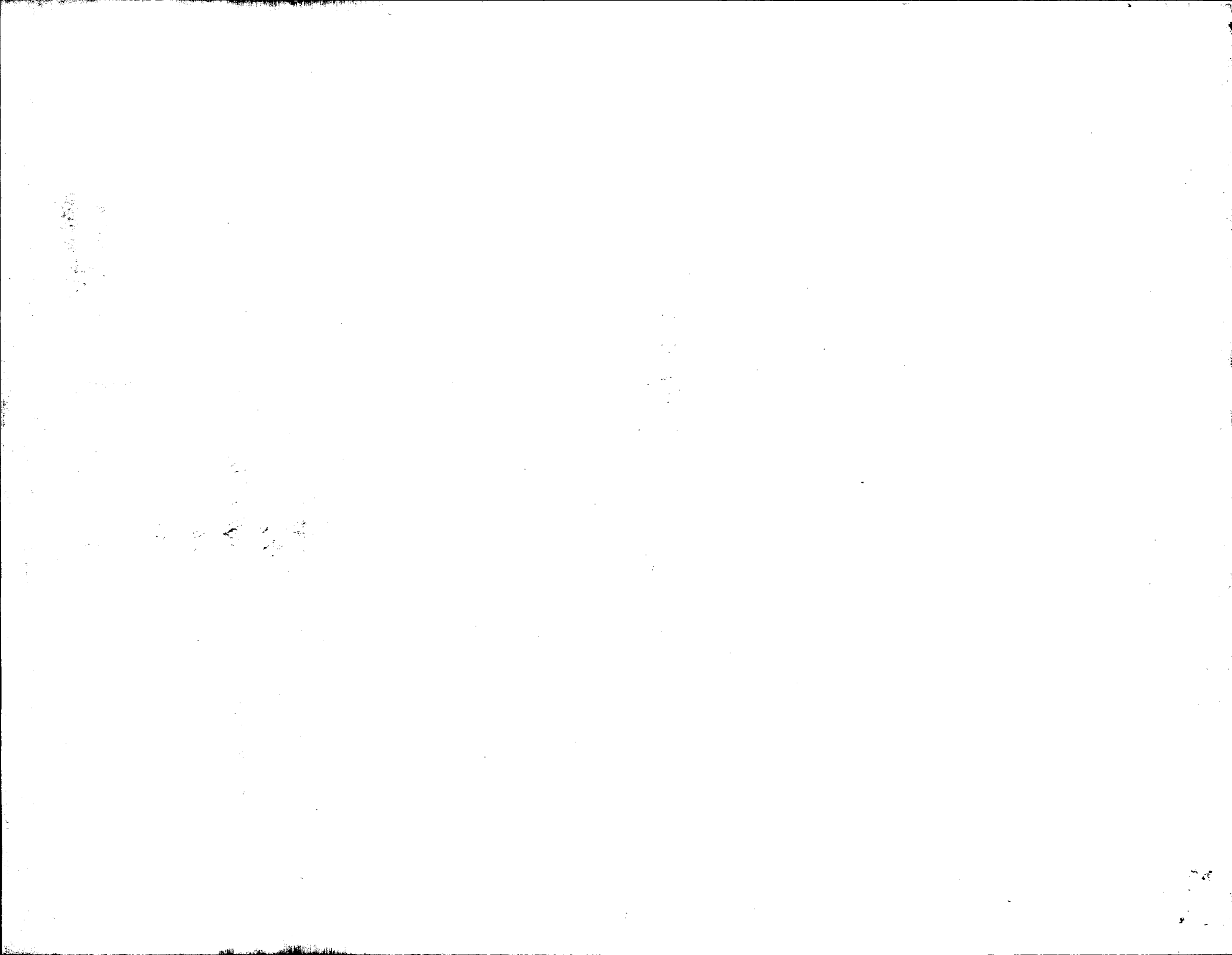
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.188	±.010	0.186	—			
0.050X45°	±.010	0.053X45°	—			
0.250	±.010	0.251	—			
R0.500	±.010	R0.500	—			
1.687	±.005	1.687	—			
2.438	±.010	2.439	—			
1.125	±.005	1.124	—			
Ø0.313	±.005 ±.001	Ø0.314	—			
0.750	±.010	0.751	—			
2.313	±.010	2.312	—			
0.756	±.010	0.756	—			
3.000	±.010	3.004	—			
Ø0.507	±.005 ±.001	Ø0.508	—			

Measured by: <i>mk</i>	Audited by: <i>EP</i>	Prototype Approval:
Date: 06/03/20	Date: 06/03/20	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



TNM**ANODISATION et PEINTURE TNM INC.****FACTURE
INVOICE**

21 chemin de l'Aviation, QC H9R 4Z2
Telephone: (514) 429-7777 Fax: (514) 429-5108
Certifié ISO 9001-2000 / ISO 9001-2000 certified
Certifié NADCAP / NADCAP certified

46961

05-Apr-2006

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE:** **PO00000842**

CONDITIONS / TERMS:**NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PRIX UNITAIRE UNIT PRICE	EXTENSION
1	6	6 ✓	VARIOUS	VARIOUS	\$0.00	\$0.00
			MINIMUM CHARGE			\$125.00
					SUB TOTAL:	\$125.00
					TPS/GST:	\$8.75
					TVQ/PST:	\$0.00
					TOTAL AMOUNT DUE:	\$133.75

RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2

No de TPS / GST # : 891559734 RT CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
No de TVQ / QST # : 1019307154 TQ000 CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû à la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.